

D3752-1

Work Order ID 109403

B109403

\*109403\*

Page 1

November-22-13 7:45:44 AM

Item ID: D3752-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Seat Frame

Start Date: 11/21/13 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 11/21/13 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 13-11-22 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3752

Rev C

100

0.00

\*100\*

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Cut sheet to required size

V4

DL  
13/11/22

105

0.00

\*105\*

HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 245°FTime IN: 7:00 pm 13/11/21Time OUT: 7:00 am 13/11/22

X6

DL  
13/11/22

# Work Order ID 109403

November-22-13 7:45:44 AM

**\*109403\***

Page 2

Item ID: D3752-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Seat Frame  
 Start Date: 11/21/13 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 11/21/13 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
<b>*110*</b>						x5	x1		Wh 13/11/22
Thermotorm	Memo	0.00							
Thermoforming Machine	Thermoform as per Dwg. D3752 and folio (FTA022 ) using tool DT 8997								
	Dwg. Rev. <u>C</u>								
	Folio Rev. <u>C</u>								
	Visually inspect for proper formation of each part								
140		0.00							
<b>*140*</b>						x5			Wh 13/11/25
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	1) Trim to Finished Dimensions								
150	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*150*</b>						x5			Wh 13/11/25
QC	Memo	0.00							
Quality Control	Complete FAI								

LAST PAGE

# Work Order ID 109403

November-22-13 7:45:44 AM

**\*109403\***

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Item ID: D3752-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Seat Frame

Stop **\*NS2\***

Start Date: 11/21/13 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 11/21/13 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
<b>*160*</b>						S			
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: _____	0.00							
<b>*170*</b>									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

DAS  
27  
9-89  
B 11 26

13/4/26 (5) DAS 32 9-89

13/11/28

13-11-24

# Picklist Print

November-22-13 7:45:50 AM

Page 1

Work Order ID: 109403

\*109403\*

Parent Item: D3752-1

\*D3752-1\*

Parent Item Name: Seat Frame

Start Date: 11/21/13

Required Date: 11/21/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV: A New Issue 08.06.03 DL verified by:DD  
 IPP Rev. B Dwg. Update 08/07/22 DL IPP Rev. C  
 Dwg. Update Shorter length 08/10/28 DL IPP Rev D Add Step 105  
 Dry Material 10/04/21 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MLEXS.125-F60029-04		Purchased	No			100	sf	1,699.752	10.667	86			
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\*MI FXS 125-F60029-04\*

GE PLASTICS LEXAN SHEET

\*\*

Location

Loc Qty

Loc Code

MAT018

1699.752

124866

286.792

m126425

1412.96

Y.  
13/11/25

86 sq ft

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 109403
<b>Description:</b> Seat Frame		<b>Part Number:</b> D3752-1
<b>Inspection Dwg:</b> D3752	<b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			
Edges and corners such as thinness, cracks and sharp edges	✓			

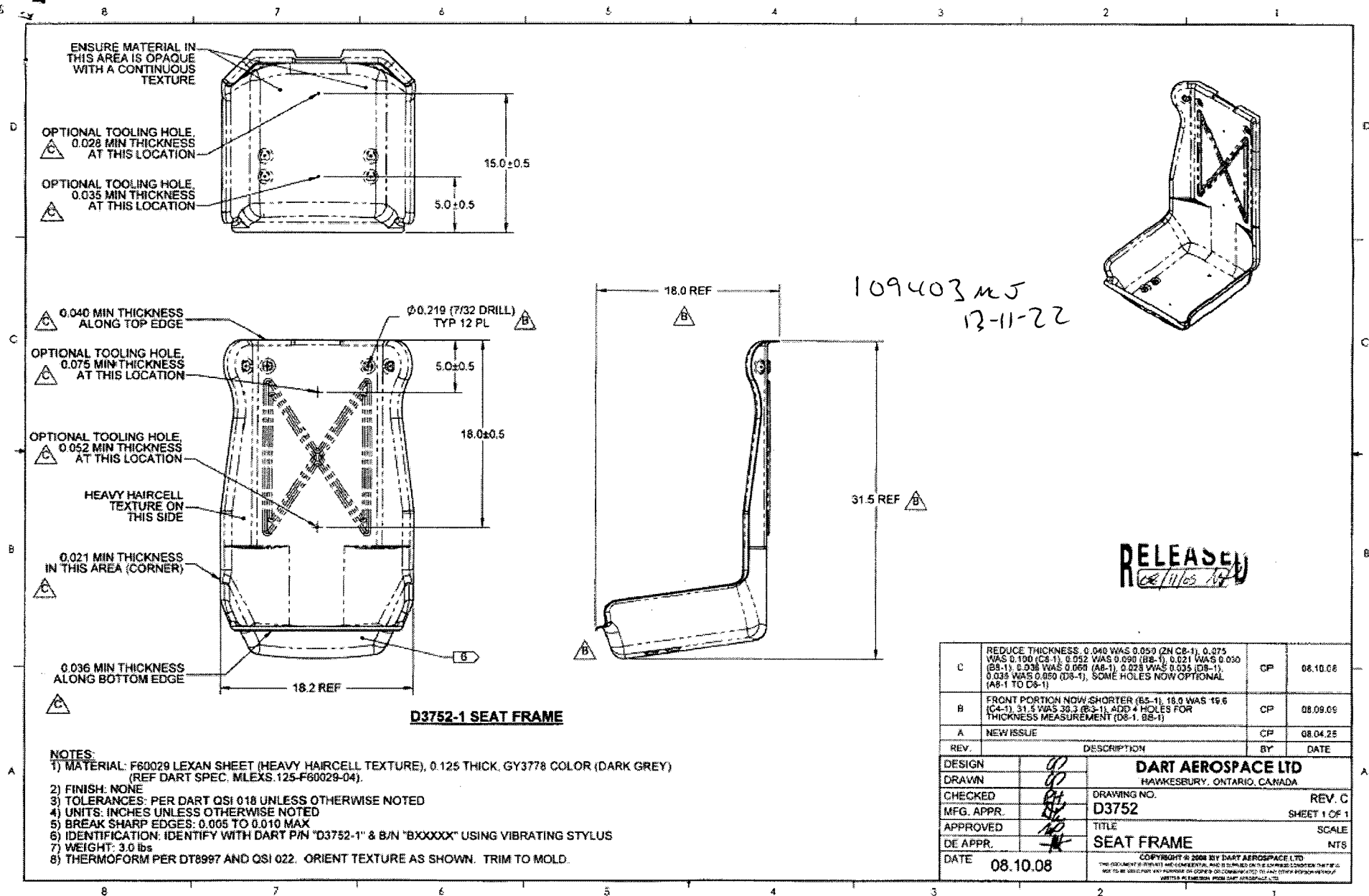
Measured by: DK Date: 13/11/22

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.028	Min	0.060"	✓			
0.035	Min	0.064"	✓			
0.040	Min	0.071"	✓			
0.075	Min	0.109"	✓			
0.052	Min	0.081"	✓			
0.021	Min	0.037"	✓			
0.036	Min	0.068"	✓			

Measured by: DK Date: 13/11/25  
Audited by: DAS Date: 13/11/26  
27  
9-89  
Prototype Approval: 9-89 Date:

Rev	Date	Change	Revised by	Approved
A	08.11.28	New Issue	KJ/DL <u>AK</u>	<u>AK</u>



NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Ad Date: 13/11/22QA Closed: Ad Date: 13/11/29

Work Order: <u>109403</u> Part No. <u>03752-1</u> NCR No. <u>13-3277</u>	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b> <table style="width:100%; font-size: small;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input checked="" type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input checked="" type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input checked="" type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>	13/11/22	110	1	DID NOT FORM WELL Mould Too Cool R. Operator error mould was not hot enough No correct procedure for working (FAR Folio not complete)	DAS 16 9-89  Q5202 13/11/22	Scrap 1 part No Replac. \$ 5.96	Dh 13/11/22	DAS 27 9-89 13/11/27	DAS 16 9-89 Q5202 13/11/24
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input checked="" type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

## FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input checked="" type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other